



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3130-55-119-3

Job Sheet 201356



Part No: RBW109-3130-55-119-3

Job Qty: 8 pcs

20 pcs D.A.

Part Name: Rod



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-55-119 Rev 4 IPP Rev. A 19.09.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	6 pcs	11/1/19	11/1/19	1.00	3.00	SL-154 - 1		/ 19/10/28
110	QC 2	6 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		/ 19/10/28
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S226855



Part: RBW109-3130-55-119-3

Job No: 201356

Serial No/Batch: S226855

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 10/28/19

					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
115	NV5000 - 1 - B4B	6 pcs	11/1/19	1.00 6.00	NV5000 - 1 - B4B	ALA/19-10-31
					NV5000 - 2 - B4B	
120	QC 2	6 pcs	11/1/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	ALA/19-10-31
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	6 pcs	11/1/19	0.00 0.00	QC 8 - 12	ALA/19-11-05
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	

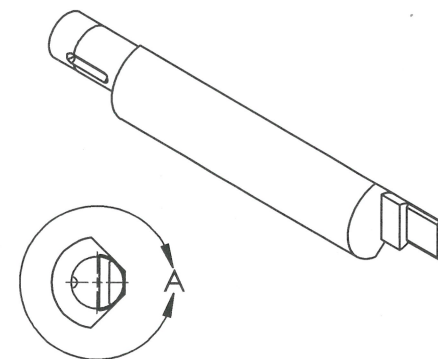
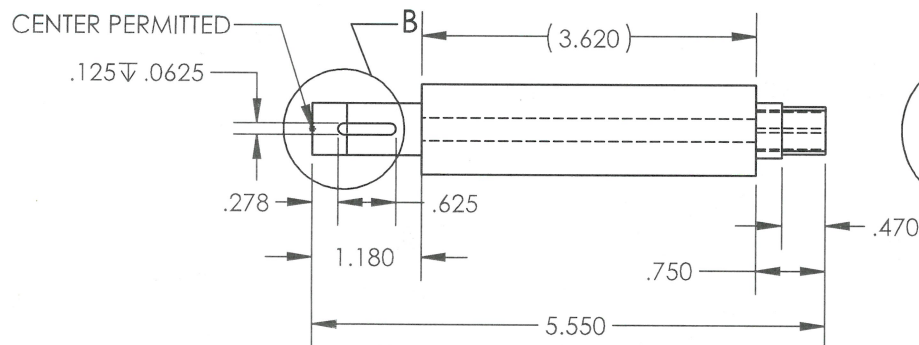
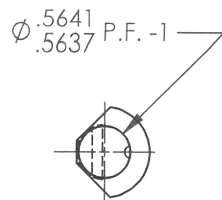
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140	Outsource - 13 - Zinc Plating	6 pcs	11/1/19	GRO002-VC	2019-11-07
150	Packaging 2-2 - Receive - B4B	6 pcs	11/1/19	0.00 0.00	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
160	QC 6	6 pcs	11/1/19	0.00 0.00	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
170	Packaging 3-1 - Stock - B4B	6 pcs	11/1/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

				Packaging 3 - 10 - B4B	ALL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21	DAS 21 NOV 28 2019
				QC 21 - SA - 70	
Part Op 100 - 1-Machine as per folio FC <u>FD025</u> FOLIO REV: <u>AA</u> DWG REV: <u>4</u> 2-Deburr Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 115 - 1-Machine as per folio FC <u>FD025</u> FOLIO REV: <u>AA</u> DWG REV: <u>4</u> 2-Deburr 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - -Issue P/O; <u>45034</u> -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required 150 - (Receive & Inspect for Damage & Mat'l Certs) 160 - QC6- All purchased or subcontracted products 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R1.000	AISI 4140 Quenched & Tempered Steel Round Bar 1.000" Dia.	2.8200 ft (.47 ea)	100-SL-154 - 1	<u>5039068</u>	<u>5226725</u>
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	MT-4140QT-R1.000	3	6	0	
Part Specifications					
Specifications could not be found.					

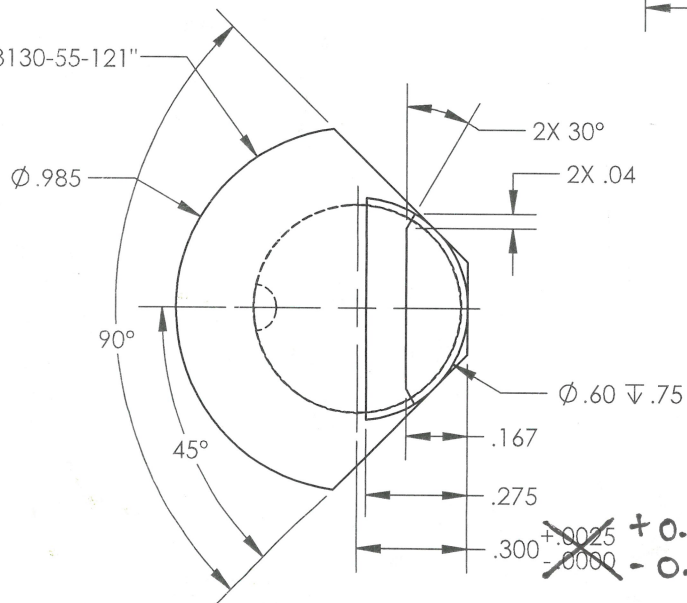
Plex 10/2/19 7:50 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

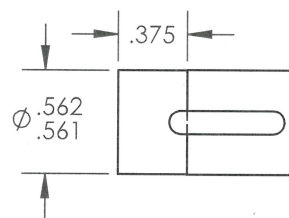
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-3 DELETED ENGRAVE NOTE WAS ENGRAVE P/N "-121". ADDED NOTE "CENTER PERMITTED". ADDED CUT-EXTRUDE Ø561-562 X .375 FOR CLEARANCE.	6/12/2013	BIM	GE
3	-3 REVERSED HEIGHTS ON STEP. ADDED FLAT ON INSIDE. CH'D THICKNESS ON STEPS. CH'D Ø FROM 1.000 TO .985.	4/9/2014	JAG	GE
4	-3 CH'D TOLERANCE ON DIM WAS .30 IS .300 +.0025 -.0000.	5/7/2014	DPD	GE



ENGRAVE
"RBW109-3130-55-121"



DETAIL A
SCALE 2:1



DETAIL B
SCALE 1:1

~~+.0025~~ +0.0000
~~-.0000~~ -0.0025

(-3)

ROD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 20,356 M15
19-10-02

 RED BARN MACHINE	
TITLE SUPPORT ASSY	
DWG NO. RBW109-3130-55-119-3	REV 4
MAT'L 4140 Q & T	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
XX ± .01 ANGLES ± .5°	FINISH CAD PLATE YELLOW
X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:2	DATE 4/1/2011
SHEET 3 OF 3	



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045034



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045034

PO Date: 11/7/19

Due Date: 11/15/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-11-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201356	RBW109-3130-55-119-3	RBW109-3130-55-119 Rev 4	Rod -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed - X8	-	11/15/19	8 pcs	0 pcs	8 pcs	\$5.625/pcs	\$45.00
											NOV 15 2019	
2	195384	RBT400218-7	RBT400218 Rev 2	Adapter -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed - X8	-	11/15/19	8 pcs	0 pcs	8 pcs	\$5.625/pcs	\$45.00
											NOV 15 2019	
Grand Total:												\$90.00

Guerin



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PURCHASE ORDER

POHB045034



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/11/19 8:49 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023956-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023956 - 1

Livré à / Ship to

DART AEROSPACE LTD

 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
13-Nov-2019		Jigar Patel		POHB045034				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3130-55-119-3 Rev.4	RBW109-3130-55-119 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2	ZINC CH	8 ✓	8 ✓	0	0	0
2	RBT400218-7 Rev.2	RBT400218 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2	ZINC CH	8	8 ✓	0	0	0

RECEIVED

NOV 14 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

14

Dec 3d/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7779

Route update only

Job: 201356		DISPOSITION		DEPARTMENT/PROCESS			
Part No. RBW109-3130-55 -119-3		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: 10/21/2019		Sequence #: 100		QTY Affected: 20		MRB (QSI042)	
Description Work Order Deviation				Disposition			
DIM WAS 0.300 + 0.0025 / - 0.0000 DIM IS 0.300 + 0.0000 / - 0.0025 DIM WAS 2X .04 DIM IS 0.02 2 PL				THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION WILL REMAIN THE SAME			
				Completed By ALH 19-10-31 Lead hand / Supervisor mf 19/11/01 QC / QA Coordinator DAS 9 9-89 19-11-05			
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☒ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					